

NAME OF THE STEP

STEP DESCRIPTION

SPECIAL CONSIDERATIONS

WORK WAITING for this Step

C-T CYCLE TIME

OF PEOPLE

S-T TOTAL STAFF TIME

V-A VALUE ADDED %

R-N-V-A REQUIRED NON-VALUE-ADDED %

C-O CHANGE OVER TIME

U-T UP TIME %

F-P-Y FIRST PASS YIELD

NOTES: